

Date: Thursday, 28/08/2008 10:14:18 AM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 41655		
Estimate Number	: 10260		
P.O. Number	:	Part Number	: D23623
This Issue	: 28/08/2008 S.O. No. :	Drawing Number	: D2362 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 38766	Material	:
Written By	:	Due Date	: 28/08/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>mf 08-08-28</u>		
Comment	: Est: G 00.05.18 Added inspection level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Step Support
Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	37477

mf 08-08-29 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

28 08/08/29 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

28 08/08/29 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mf 08/08/30 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

N/A 08/08/30 10

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

(10X)

START TIME:

1:50

mf 08/08/02

Date: Thursday, 28/08/2008 10:14:19 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 41655

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 450 ^{OF}

FINISH TIME: 2-20

M-L

08/09/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



LD



Comment: INSPECT POWDER COAT

08-09-02

(X)

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B38053

CP 08/09/03

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B38054

CP 08/09/03

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch

M109/09

M107860

CP 08/09/03

(10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/03

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 478

8/9/3

(10x)

54

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 41655

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03

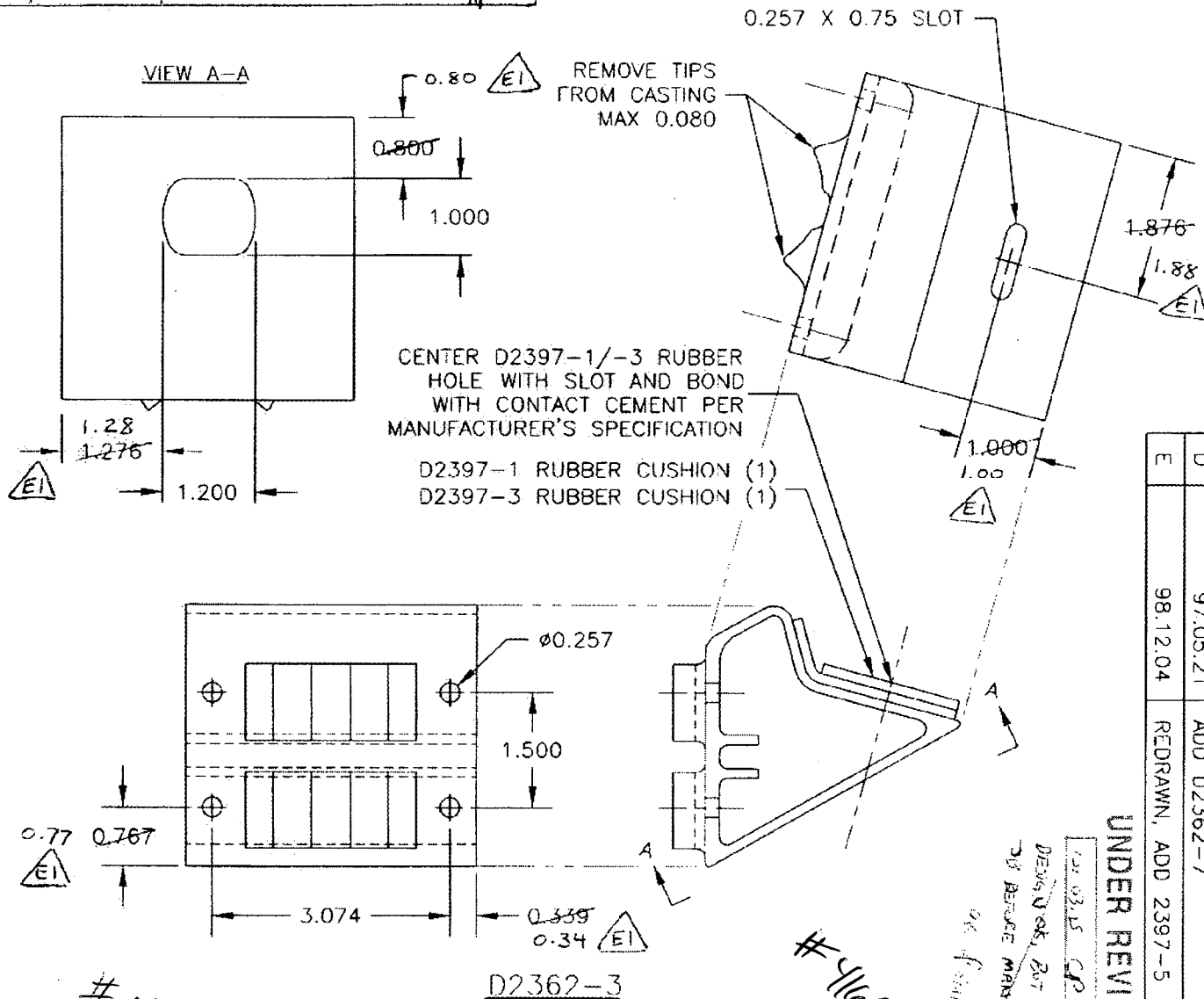
LF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.09.03

EI 03.10.07 TOLERANCE CHANGE ~~RT~~RELEASED
95.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW		HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE		D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5
SCALE		1:2

NOTES:

MAKE FROM D2265

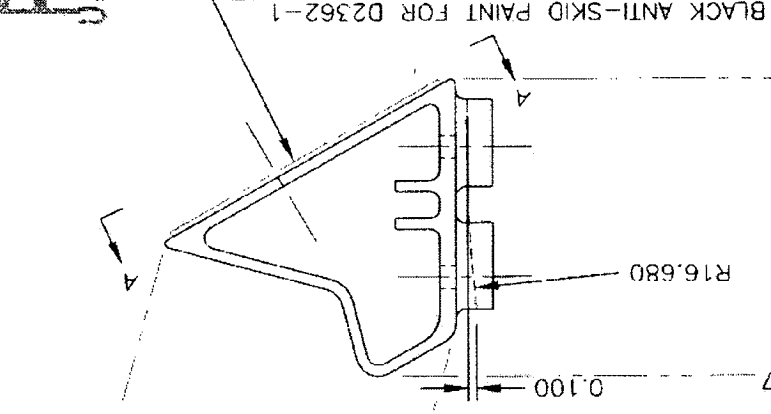
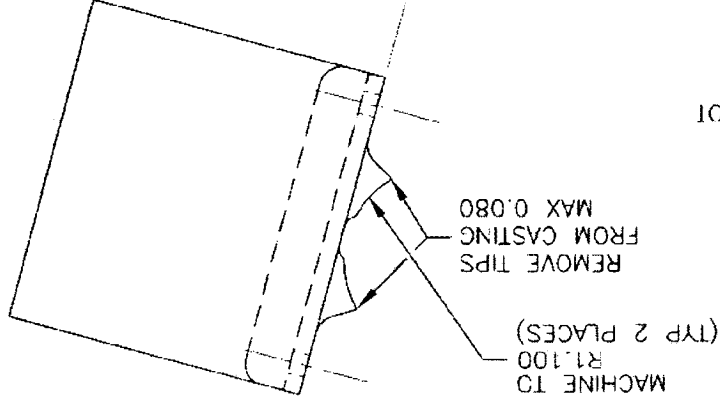
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

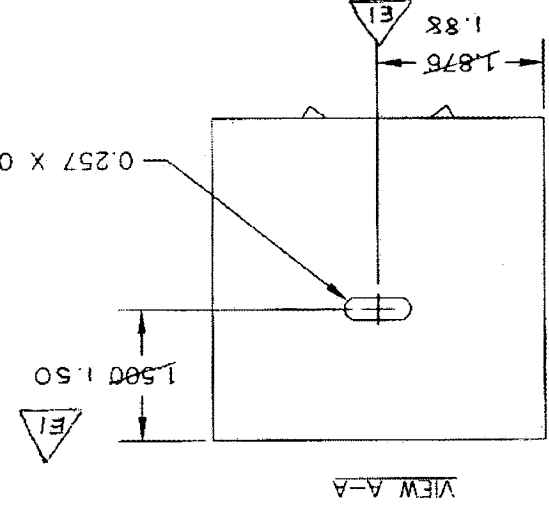


DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. E
KE	JP	SHEET 2 OF 3
DATE	TITLE	SCALE
98.12.04	STEP SUPPORT BRACKET	1:2



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5



RELEASED
98.12.14
UNDER REVIEW

D2362-5 CP

DESIGNING, BUT CHECK W/

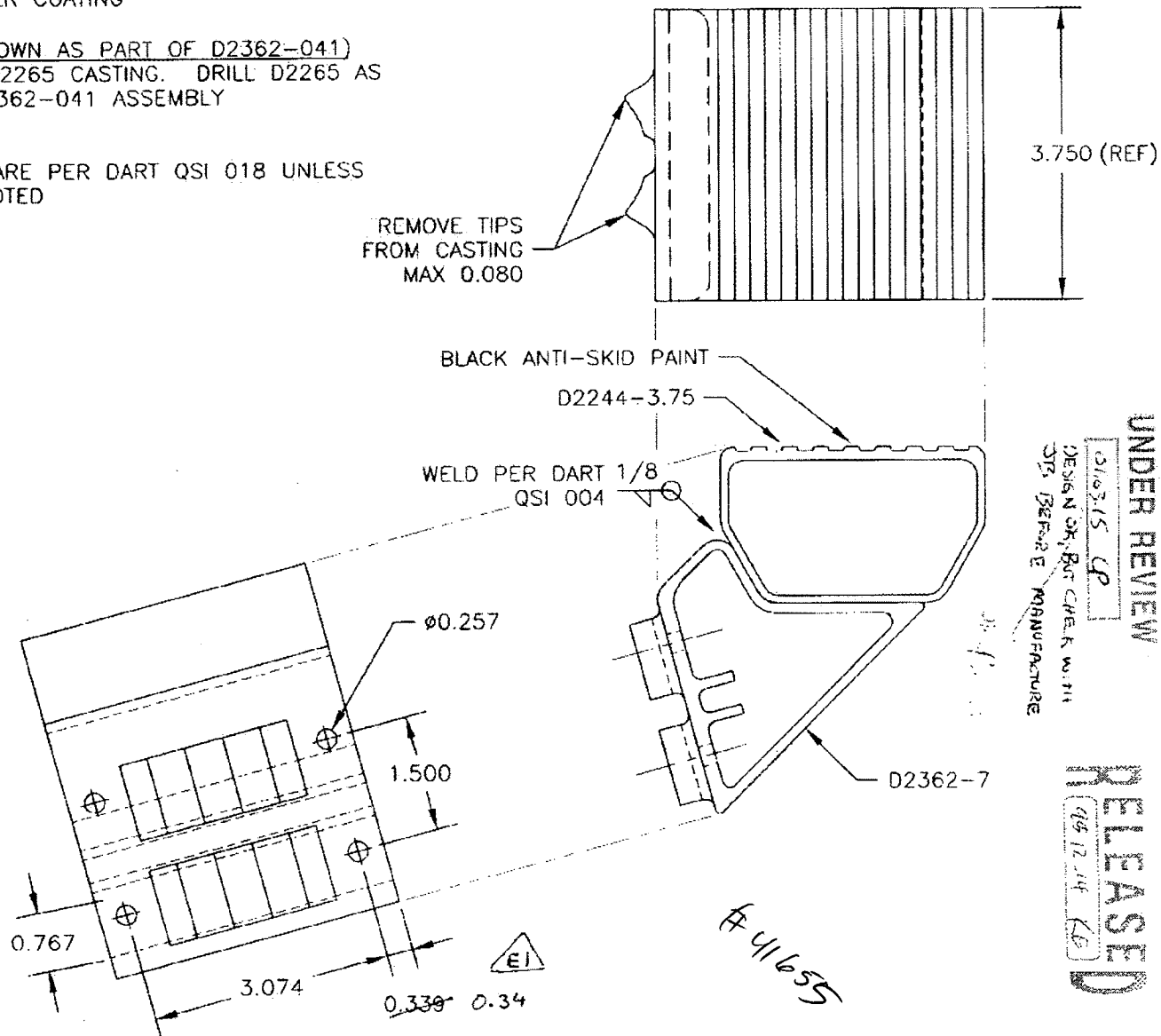
DB BEARING MANUFACTURE

4/16/55

NOTES:
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
MAKE FROM D2265
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



UNDER THE VEIL

95.12.14 (E)

010315 CP
DESIGN OK, BUT CHECK WITH
JCS BEFORE MANUFACTURE

DESIGN	DRAWING BY	DARI AEROSPACE LTD	
BW	<i>BP</i>	HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>KE</i>	<i>#</i>	D2362	SHEET 3 OF 3
DATE	TITLE		SCALE
98.12.04	STEP SUPPORT BRACKET		1:2

DART



